



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PKG ALONE
Ship ALONE

D2946-041

Job Sheet 176651



Part No: D2946-041

Job Qty: 2 ea

Part Name: Step (AS350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/26/18

Job Tracking No:

Due Date: 5/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D2946 REV.B IPP REV:A 18.04.20 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	2 Ea		5/24/18	0.00	0.00	Start Up Large Fab-7		hml 18-4-30
110	Large Fab	2 pcs		5/24/18	0.00	1.39	Large Fab 8		hml 18-4-30
120	QC	2 pcs		5/24/18	0.00	0.00	QC5		cpl
130	Large Fab	2 pcs		5/24/18	0.00	1.39	Large Fab 2		cpl
135	QC	2 pcs		5/24/18	0.00	0.00	QC9		PD 15-05-01
140	QC	2 pcs		5/24/18	0.00	0.00	QC5		PD 15-05-01
145	HandFinish	2 pcs		5/24/18	0.00	0.33	HandFinish1		GA 18-05-09
155	QC	2 pcs		5/24/18	0.00	0.00	QC7-5		cpl
180	Large Fab	2 pcs		5/24/18	0.00	1.39	Large Fab 2		cpl
190	QC	2 pcs		5/24/18	0.00	0.00	QC9 QC 10		LY 2018 05-10
200	QC	2 pcs		5/24/18	0.00	0.00	QC5		LY 2018 05-10
210	HandFinish	2 pcs		5/24/18	0.00	0.30	HandFinish1		SA 18-05-10
220	Powdercoat	2 pcs		5/24/18	0.00	0.21	Powdercoat1		BR 18-05-10
230	HandFinish	2 pcs		5/24/18	0.00	0.30	HandFinish3		BEB 18-05-11
240	QC	2 pcs		5/24/18	0.00	0.00	QC3		38
270	Packaging	2 pcs		5/24/18	0.00	0.00	Packaging3-1		Stamp 2018
280	QC21-FG	2 Ea		5/24/18	0.00	0.00	QC21		MAY 15 2018

Part Op 110 - 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2-Deburr **Ensure that 57.09" minimum extrusion is Descriptions: kept and identify to be used for D350-591-215/-216.**

130 - 1-Deburr and Bevel ends for welding 2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946 A/RAluminum Rod M130137 3-Grind End Cap welds flush

180 - Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. A/R AL ROD BATCH M130137

220 - START TIME: 12:50 OVEN TEMPERATURE: 320° FINISH TIME: 1:20 M138760

wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (.5 ea)	100-Start up Operation	5046116
D2734	Step End Plate	4 Ea (2 ea)	130-Large Fab	5012001
D2944	Step Mounting Plate	4 Ea (2 ea)	130-Large Fab	F164736

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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5066977x2

DQA: DAS 53 Date: 9-89

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: MAY 30 2018Work Order update only ☐

Work Order: <u>17660</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D2946-041</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒		
NCR No. <u>18-6882</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

Date: <u>18/5/8</u>	Step #: _____	QTY Effective: _____	MRB (QSI042) Approval <u>DAS 12 9-89</u> <u>18/5/8</u>
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Description Work Order Deviation 	Disposition Completed By: <u>CPC 18/5/8</u> Lead hand / Supervisor Approval Verification: <u>CPC 18/5/8</u> QC / QA Coordinator Approval: <u>DAS 9 18-05-22 9-89 18-05-20</u>
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Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☒ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐			
OTHER: _____					

100-Start up Operation	D2622-120C	1	178	0
130-Large Fab	D2734	4	55	0
	D2944	4	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Mounting Plate	0.257Inches + 0.006 - 0.001	0.263 0.256		Diameter
2	Step Mounting Plate	0.559Inches ± 0.010	0.569 0.549		
3	Step Mounting Plate	3.040Inches ± 0.030	3.070 3.010		
4	Step Mounting Plate	1.950Inches ± 0.030	1.980 1.920		
5	Step Mounting Plate	0.852Inches ± 0.010	0.862 0.842		
6	Step Mounting Plate	2.715Inches ± 0.001	2.716 2.714		
7	Step Mounting Plate	3.400Inches ± 0.030	3.430 3.370		

Plex 4/26/18 3:12 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ DART Aerospace Ltd. 1270 Aberdeen Street Newkesbury, ON K84 1K7 CANADA TEL.: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S066977 Part: D2946 - 041 Job No: 176651 Serial No/Batch: S066977 Revision: B Inspector:	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Supplier ☐</td> <td></td> <td></td> </tr> </table>			Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Supplier ☐																																																																																													
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